



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2521

Job Sheet 199292-A



split

Part No: D2521

Job Qty: 12 pcs

Part Name: Individual Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/19

Job Tracking No:

Due Date: 8/30/19

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV J IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	QC 6	12 pcs	8/30/19		0.00	0.00	QC 6 - 9		
							QC 6 - 68		
							QC 6 - 61		
							QC 6 - 40		
							QC 6 - 81		
130	HAAS 4 Axis - B4B	12 pcs	8/30/19		1.00	20.83	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
140	QC 2	12 pcs	8/30/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		



Container No: S209627



Part: D2521

Job No: 199292 - A

Serial No/Batch: S207788

Revision: J

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/28/19

DART A-08-29

				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
150 QC 8	12 pcs	8/30/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
160 Packaging 3-1 - Stock - B4B	12 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	

SEP 08 2019

SEP 19 10 08 12 1

ST479A

SEP 03 2019

					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	12 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21	DAG
					QC 21 - SA - 70	21
					QC 21 - SA - 53	9-89 SEP 03 2019
Part Op 110 - QC6- All purchased or subcontracted products Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2521 Identify as D2521 140 - (QC2- Inspect parts off machine FAI/FAIB) 150 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Job BOM records could not be found.						
Job Allocations						
Job Allocations could not be found.						

Part Specifications

Specifications could not be found.

Plex 8/28/19 10:54 AM dart.lacelle.linda



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2521

Job Sheet 199292



Part No: D2521

Job Qty: 20 pcs

Part Name: Individual Bearpaw



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/16/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV J IPP Rev:A 08-10-01 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Purchasing	20 pcs	8/30/19	8/30/19	0.00	0.00	Purchasing - 1		AUG 21 2019
							Purchasing - 2		
							Purchasing - 3		
100	Packaging 2-1 - Receive - B4B	20 pcs	8/30/19	8/30/19	0.00	0.00	Packaging 2 - 1 - B4B		AUG 21 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 -		



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Container No: S207788



Part: D2521

Job No: 199292

Serial No/Batch: S207788

Revision: J

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/21/19

Plex 8/16/19 12:43 PM Dart.lajeunesse.marie

					B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
110	QC 6	20 pcs	8/30/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	81
					QC 6 - 40	9-89
					QC 6 - 81	
130	HAAS 4 Axis - B4B	20 pcs	8/30/19	1.00 34.72	HAAS - 1 - B4B	
					HAAS - 2 - B4B	
					HAAS - 3 - B4B	
					HAAS - 4 - B4B	
140	QC 2	20 pcs	8/30/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	

Plex 8/16/19 12:43 PM Dart.lajeunesse.marie

					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
150	QC 8	20	8/30/19	0.00 0.00	QC 8 - 12	
		pcs			QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
160	Packaging 3-1 - Stock - B4B	20	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
		pcs			Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
						Plex 8/16/19 12:43 PM Dart.lajeunesse.marie

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	20 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 90 - 1-Issue PO; _____ 2-Cut blanks as per D2521_BLANK file.

Descriptions: 100 - Receive & Inspect for Damage & Mat'l Certs.

110 - QC6- All purchased or subcontracted products

130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage Folio and Dwg D2521 Identify as D2521

140 - (QC2- Inspect parts off machine FAI/FAIB)

150 - (QC8- Inspect parts - second check)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Raw mat
already @
Dwal

Job BOM

Part / Item	Component Name	Quantity	Operation	DAS	Container
D2521P	Individual Bearpaw	20 Ea (1 ea)	90-Purchasing	35	520787
MUMWB0		140sf (7sf each)		9-89	SIT0514

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	D2521P	20	0	0

Part Specifications

Specifications could not be found.

Plex 8/16/19 12:43 PM Dart.lajeunesse.marie

RELEASED
06 08 23

199292 M5
1928/6
UNCONTROLLED COPY
ENGINEERING
RETURN
SUBJECT TO AMENDMENT
199292 M5
1928/6

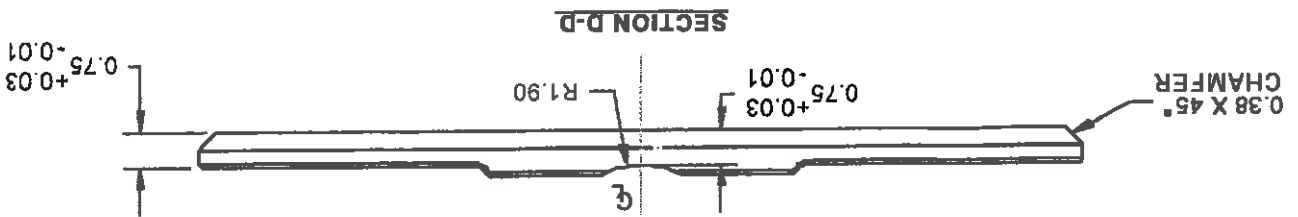
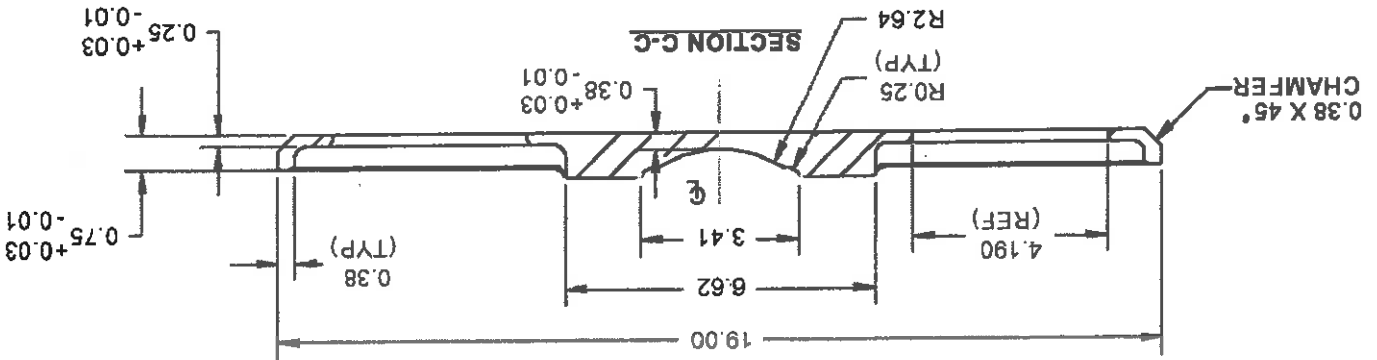
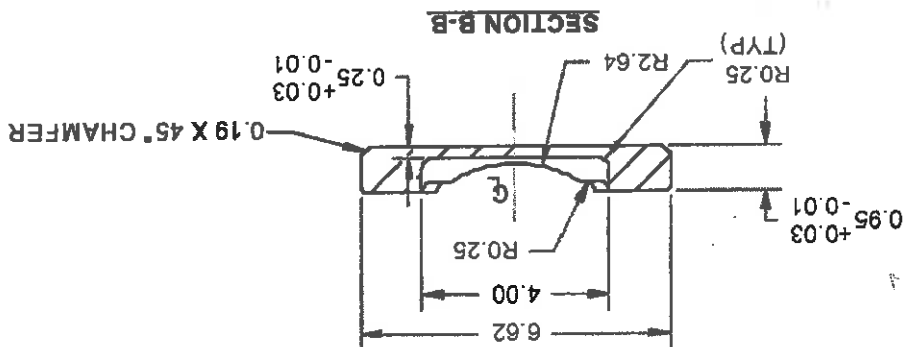
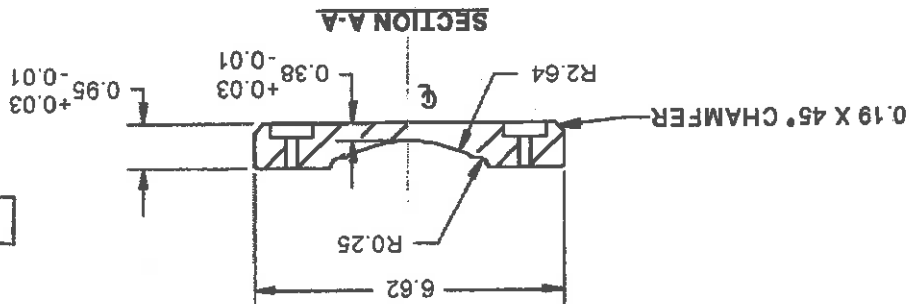
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWN BY CB	CHECKED [Signature]	APPROVED [Signature]	D2521	REV. J SHEET 1 OF 3 SCALE NTS	A	95.11.28	NEW ISSUE
						B	96.01.11	SHOW BENDING MOVE HOLES
						C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING
						D	96.05.14	ADJUSTED BEAR PAW THICKNESS
						E	96.12.18	43.500 WAS 46.750
						F	97.05.07	ADDED REAR POCKET, MOVED HOLES
						G	98.08.06	ADD C'BORE AND CHAMFER EDGES
						H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.
						I	05.05.20	REMOVE BEND; CHANGE TOLERANCES
						J	06.07.28	CHANGE FOR FLOAT SKIDTUBE





DESIGN	DRAWN BY	DATE	06.07.28
CHECKED	APPROVED	TITLE	205 BEARPAW
C.B.	D2521	SCALE	1:4
DART AEROSPACE LTD	REV. J	SHEET 3 OF 3	
HAWKESBURY, ONTARIO, CANADA			

RELEASED
66-8-22





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044289



Supplier: ACI002-VC
Acier Duval Steel
5888 Country Road 17
Plantagenet
ON
K0B 1L0 Canada
Phone: 613-673-5474
Fax: 613-673-4576

PO No: POHB044289

PO Date: 8/19/19

Due Date: 8/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-08-20

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199292	D2521P		Individual Bearpaw as per Dwg D2521_Blank File	Firmed	-	8/26/19	20 Ea	0 Ea	20 Ea	\$57.77/Ea	\$1,155.40
						20	X	AUG 21 2019				
2	199291	D3075-1P		Bearpaw (Foot Print Only), as per Dwg D3075_blanknest file	Firmed	-	8/26/19	10 Ea	0 Ea	10 Ea	\$19.97/Ea	\$199.70
						10	X	AUG 21 2019				
3	199290	D3529-1P		Bearpaw as per Dwg F3529-1_4x8 file	Firmed	-	8/26/19	18 Ea	0 Ea	18 Ea	\$23.37/Ea	\$420.66
						18	X	AUG 21 2019				
4	199293	D2432P		Bearpaw 19" X 24", as per DWG D2432_nest7 file	Firmed	-	8/26/19	8 Ea	0 Ea	8 Ea	\$35.26/Ea	\$282.08
						8	X	AUG 21 2019				

Grand Total: \$2,057.84

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material Identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance - NOT SUPPLIED

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/20/19 11:20 AM Dart.Guerin.Kimberley

A.D.S.

Acier Duval Steel

Fabrication shop: aluminum and stainless steel
plate cutting, bending, rolling and punching services.

Atelier de fabrication: aluminium et acier inoxydable
Service de coupage, pliage, roulage et poinçonnage.

1-866-831-5722

T: 613-673-4574

info@adsindustries.com

5888 County Rd. 17

Plantagenet, ON.

K0B 1L0

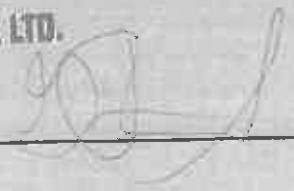
Packing Slip:

9024

Aug 21, 2019

1 of 1

Sold to:	Ship to:
Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No: PCHRD01230 ✓	Sold By:
Shipped By:	Ship date:
Tracking No:	

Item No	Quantity	Description
Water jet cutting	20 ✓	Waterjet cutting only, customer material UHMW 1" black. Individual Bearpaw as per Dwg D2521_Black file, Job 19929. Part#D2521P ✓
Water jet cutting	10 ✓	Waterjet cutting only, customer material UHMW 1" black. Bearpaw (Foot Print Only) as per DWG D3075_blackprint file. Job 19929. Part#D3075-1P ✓
Water jet cutting	18 ✓	Waterjet cutting only, customer material UHMW 1" black. Bearpaw as per Dwg F3529_4x8 file, Job 19929. Part#D3529-1P ✓
Water jet Cutting	9 ✓	Waterjet cutting only, customer material UHMW 1" black. Bearpaw 19" x 24" as per DWG D2432_black file, Job 19929. Part#D2432-1P ✓
RECEIVED AUG 21 2019 DART AEROSPACE LTD. 		
Comment: ADS Industries = Facebook & Instagram		

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	0.261	✓		G.P.	
B	0.90	0.96	0.930	✓		Ver	
C	0.27	0.330	0.310	✓		Ver	
D	0.470	0.530	0.500	✓		Ver	
E	21.740	21.760	21.750	✓		TAPE	
F	0.72	0.780	0.750	✓		Ver	
G	0.35	0.410	0.380	✓		Ver	
H	11.490	11.570	11.500	✓		TAPE	
I	3.41	3.47	3.440	✓		Ver	
J	11.790	11.810	11.800	✓		TAPE	
K	9.47	9.53	9.500	✓		TAPE	
L	7.190	7.210	7.200	✓		Ver	
M	6.910	6.970	6.940	✓		Ver	
N	44.47	44.530	44.500	✓		TAPE	
O	6.590	6.650	6.620	✓		Ver	
P	0.940	0.980	0.970	✓		Ver	
Q	18.97	19.03	19.00	✓		TAPE	
R	0.350	0.410	0.380	✓		Ver	
S	0.740	0.780	0.760	✓		Ver	
T	0.240	0.280	0.265	✓		Ver	
U	0.370	0.410	0.395	✓		Ver	
V	0.740	0.780	0.770	✓		Ver	
W	0.740	0.780	0.760	✓		Ver	

Measured by: DAS 52	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 9-89 11/08/27	Date: 19/08/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM	